

HiFill® PK GF33

 Techmer Polymer Modifiers - *Polyketone*
General Information
General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Filler / Reinforcement	<ul style="list-style-type: none"> Glass Fiber, 33% Filler by Weight
Features	<ul style="list-style-type: none"> Low Moisture Absorption
Appearance	<ul style="list-style-type: none"> Colors Available Colors Available
Forms	<ul style="list-style-type: none"> Pellets
Processing Method	<ul style="list-style-type: none"> Injection Molding

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.47		ASTM D792
Molding Shrinkage - Flow (0.125 in)	6.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.40	%	ASTM D570
Mechanical			
Tensile Strength (Break)	20300	psi	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	972000	psi	ASTM D790
Flexural Strength	27600	psi	ASTM D790
Impact			
Notched Izod Impact (73°F, 0.125 in)	2.2	ft·lb/in	ASTM D256
Hardness			
Rockwell Hardness (R-Scale)	121		ASTM D785
Thermal			
Deflection Temperature Under Load (66 psi, Unannealed)	419	°F	ASTM D648
Deflection Temperature Under Load (264 psi, Unannealed)	410	°F	ASTM D648
Melting Temperature	432	°F	
CLTE - Flow	5.0E-5	in/in/°F	ASTM D696
Electrical			
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (Method A (Short-Time))	450	V/mil	ASTM D149
Flammability			
Flame Rating	HB		UL 94

Processing Information

	Nominal Value	Unit
Injection		
Injection Rate	Moderate-Fast	
Back Pressure	50.0 to 100	psi

Injection Notes

Screw Speed: Medium
 Recommendations for Molding and Tool Conditions: Well vented
 Moisture Content, as received: Product is packaged at 0.2% or less.
 Recommended Max Moisture: 0.12% down to 0.08%

